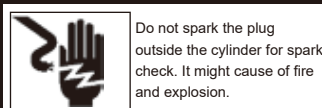
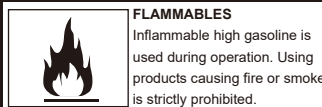
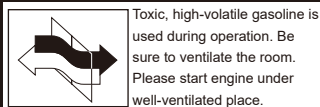
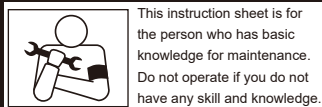


CODE		CODE	
85cc 214-1013410		85cc 214-1016410	
88cc 214-1013420 / (CHROME CYLINDER) 215-1013402		88cc 214-1016420 / (CHROME CYLINDER) 215-1016402	
APPLICATION : A		APPLICATION : B / C	
MONKEY / GORILLA	FNO,Z50J-1000001 ~ 1510400	MONKEY / GORILLA	FNO,Z50J-1600008 ~ 1805927
CHALY ※ 1)	FNO,CF50-1000002 ~ 2899999	MONKEY / GORILLA	FNO,Z50J-2000001 ~
DAX (6V ST50)	FNO,ST50-1000001 ~ 6346265		FNO,AB27-1000001 ~ 1899999
CD50	FNO,CD50-1100001 ~ 1330600	MONKEY BAJA	
	FNO,C50-N000002 ~ V488897	DAX (12V AB26)	
	FNO,C50-Z000002M ~ Z069126M	JAZZ	
SUPER CUB50	FNO,C50-3000001 ~ 5121324	MAGNA50	FNO,AC13-1000001 ~
	FNO,C50-5200011 ~	MOTRA	
※ 1) In case of CHALY, machining is required because cylinder fin and leg shield interrupt each other.		CHALY ※ 1)	FNO,CF50-3000031 ~
		MONKEY R / RT	
		CD50 / BENLY50S / BENLY CL50	FNO,CD50-1500001 ~
		SUPER CUB50	FNO,C50-8000001 ~ 9501323
		PRESS CUB	FNO,C50-9600001 ~ 0095210
		LITTLE CUB	FNO,C50-0200001 ~
			FNO,AA01-1000001 ~
		GIORCUB	FNO,AF53-1000001 ~
		XR50R/CRF50F	AE03
		※ 1) In case of CHALY, machining is required because cylinder fin and leg shield interrupt each other.	

- Thank you for purchasing Kitaco product. Read and understand the instruction before installing.
- Special tools are required to install.
- After installation, please use this sheet as setting manual.
- ※ Instruction sheet is not included to repair parts. Please keep this instruction safe.

### ATTENTION (MUST READ)

- This product is for racing use. It is out of warranty. Unable to ride on public road with installed vehicle. We are not responsible for violation of law or damages and accidents caused by assembling mistake and improper setting.
- This kit use stock cylinder head and camshaft. The cylinder head and parts inside are not included.
- By installing this product, changing carburetor, plug, gear, etc and setting is required. If riding with stock setting, it unables to power up, cause of burning and break. Please set up to match the engine. Please change stronger clutch and oil pump. (Refer to the No.4 option parts list.)
- This big bore kit is for stock stroke. Do not install stroke up crank shaft.
- Please follow this instruction sheet. Do not modify the way which is not listed or it will cause burning, damage and trouble.
- Please ask authorized mechanic for assembling and setting. Ask a specialist at specialty shop if you do not understand the role of the surrounding parts.
- Change engine oil after break in (around 100km).
- Refer to the manufacturer service manual when installation.
- Bolts and nuts may get loosen by engine vibration. Make sure not to loosen any bolts and nuts before driving.
- Clean each parts by parts cleaner, etc and check the oil line is choked by using air duster.
- Oil the parts with engine oil when assembling.
- Bolts and nuts may get loosen by engine vibration. Make sure not to loosen any bolts and nuts before driving.
- Do not use engine brake, etc burden the mission. When starting engine with kick, check the gear is engaged before kick. Recommend to push start more than 2nd gear.
- Please ride under 5,000rpm when break in.

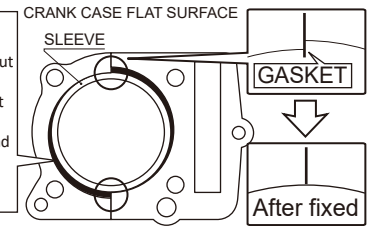


## ATTENTION WHEN INSTALLING

### 1. The clearance between cylinder sleeve and crank case through hole.

When installing cylinder, make sure that there is a gap more than 0.5mm all around cylinder sleeve and crank case side through hole. Because of the crank case tolerance, 0.5mm or less gap might interrupt the sleeve. In that case, shave crank case through hole sharply to make clearance more than 0.5mm. If the gasket sticks out from crank case matching surface, cylinder sleeve might touch the gasket because of deformation by thermal expansion, and it might cause of burning piston and oil leaking. Crank case hardness is more than tolerance, processing and assembling require extreme caution.

In case of unable to insert cylinder sleeve into crank case, o is out of the hole, please shave. Make sure that there is a gap more than 0.5mm all around cylinder sleeve and crank case through hole.



### 2. OTHER ATTENTION

- Please use unleaded premium gasoline. This is high pressure, regular gasoline may cause of knocking and breaking vehicle.
- OPTION PARTS CHARACTERISTIC
- By installing PCΦ20 big carburetor, the amount of intake air increases a lot and absolute performance improvement. By installing SPL camshaft, significant performance improves due to changes amount of maximum camshaft lift and working angle. More intake and exhaust efficiency, it makes high performance engine and high speed smoothly. Install Φ20mm carburetor, SPL high camshaft, performance muffler together make maximum output more than 6PS and maximum speed 100km/h.
- For electrical system, recommend to use power rev CDI. For the best ignition characteristic for engine performance.
- Clutch is consumable product. If it slips, stop riding and change to reinforced clutch kit. More tuning (power) requires reinforced clutch.
- In case of engine become high temperature by high speed riding under summer, etc, please install oil cooler kit.

OPTION PARTS (Please purchase in necessary.)		
	NAME	CODE
INTAKE	KEIHIN PCΦ20 LIGHT CARBURATER (specified for models) *1	110-1015506
	SUPER POWER CLEANER (Φ35)	515-6000350
	MULTI HIGH THROTTLE SET 750mm	901-0550750
ELECTRIC	POWER REV2	766-1123300
DRIVE	3 DISK DRIVE UNIT	307-1123510
OTHER	HIGH CANSHAFT (For application A)	300-1013000
	SPL HIGH CANSHAFT (For application C)	300-1083100
	(LOCKER ARM) TITANUM NUT	303-1013711
	SUPER OIL PUMP KIT (For application A / B)	331-1013300
	SUPER OIL PUMP KIT (For application C)	331-1083300
	CAP NUT & WASHER SET	313-0600000
	SUPER OIL COOLER SET (3ROW CONDENSER)	360-1133200

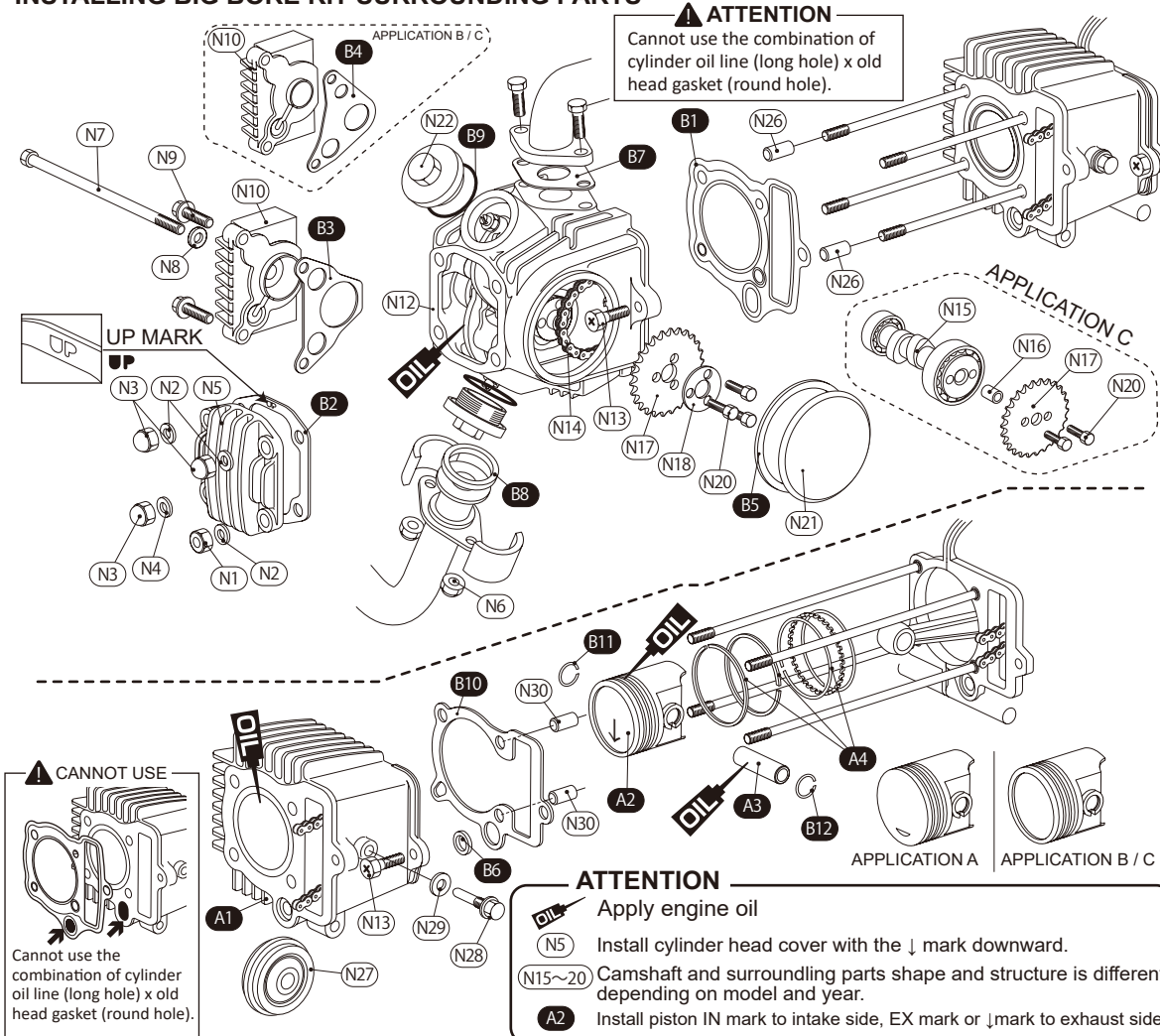
*1 KEIHIN PC20 LIGHT CARBURATER APPLICATION MODEL	
MONKEY / GORILLA	FNO,Z50J-1600008 ~ FNO,AB27-1000001 ~
MONKEY BAJA	
DAX50 (12V)*	AB26
JAZZ	AC09
XR50R/CRF50F ※	AE03
*In case of installing DAX50, Kitaco fuel cock type1 (575-0500000) is required.	
*In case of installing XR50R / CRF50F, machining throttle holder and purchase other throttle cable are required.	

### VERSION UP KIT

There are version up kit enables to tuning from light big bore kit to STD (standard) big bore kit. If you feel not enough with light big bore kit, please purchase it.

VERSION UP KIT			
▼APPLICATION	SPEC	CODE	▼REMARK
A	LIGHT88cc → STD88cc	213-1013101	*Reuse cylinder.
B	LIGHT88cc → STD88cc	213-1016001	*Reuse cylinder.
C	LIGHT88cc → STD88cc	213-1033001	*Reuse cylinder.

INSTALLING BIG BORE KIT SURROUNDING PARTS



▲ Basically, reuse genuine parts if it is unattached.

If there is a hard degradation like a blem, fatigue and wear etc on the reuse parts, please change to new ones.

PACKING LIST IS ON NO.3

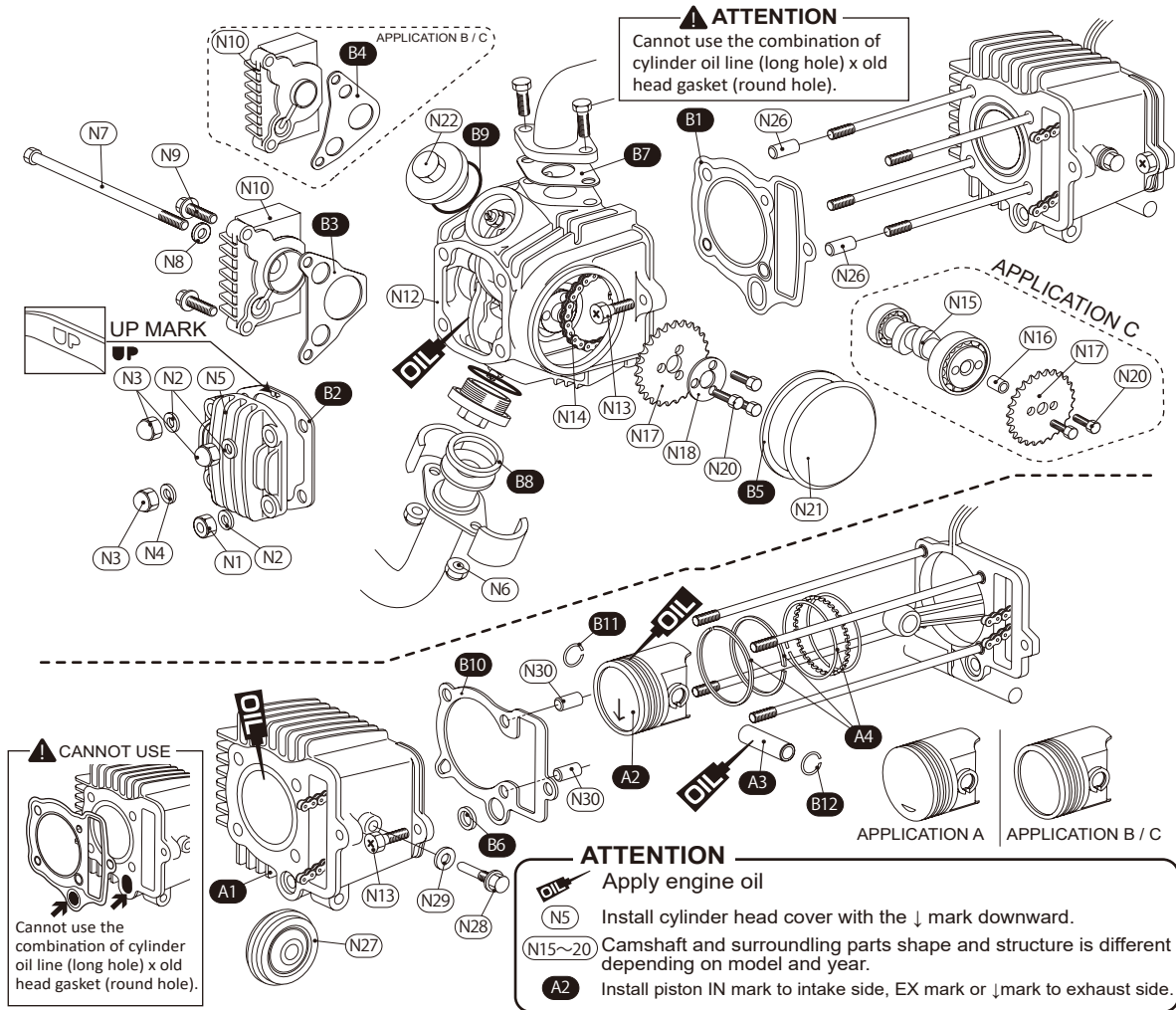
HOW TO INSTALL	
1	Remove front wheel and front fender ease to operation. (Depending on the models, it does not need to remove.)
2	Remove all oil.
3	Remove spark plug and muffler.
4	Remove 3pcs (6pcs depending on models) M6 bolts to remove left side case cover.
5	Remove gasoline inside carburator.
6	Remove manifold from engine.
7	Remove 3pcs M6 bolts and a sealing washer from right side cylinder head, then remove left and right head side cover and each head side cover gasket. * If the gasket stick to head side cover, remove by scraper, etc.
8	Remove cam sprocket installation bolt, then remove cam sprocket.
9	Remove M6 nut (1pc nut, 3pcs cap nut), 4pcs sealing washer and crossed hole M6 bolt on left side that are tighen head, then remove head cover, gasket, cylinder head assy and head gasket. * Remove 2pcs orifice O ring. * If the gasket stick to head cover and head, remove by scraper, etc.
10	Remove crossed hole M6 bolt on left side of cylinder, remove roller pin and sealing washer on left side, remove cam chain guide roller not to fall crank case, and remove cylinder. * Remove cylinder gasket, 2pcs dowel pin and orifice O ring at the same time of removing cylinder. * If the gasket stick to crank case contact surface, remove by scraper, etc.

FIGURE	NAME	TORQUE	FIGURE	NAME	TORQUE
N1	M6 NUT	1.2kgf • m	N15	CAMSHAFT	
N2	6mm FLAT WASHER		N16	DOWEL PIN 8 x 12	
N3	M6 CAP NUT	1.2kgf • m	N17	CAM SPROCKET	
N4	6mm COPPER FLAT WASHER		N18	CAM SPROCKET SIM	
N5	CYLINDER HEAD COVER		N20	M5 BOLT	0.8kgf • m
N6	M6 FLANGE NUT	1.2kgf • m	N21	L CYLINDER HEAD SIDE COVER	
N7	M6 x 110 BOLT	1.0kgf • m	N22	TAPPET CAP	1.2kgf • m
N8	6mm SEALING WASHER		N26	DOWEL PIN 8 x 14	
N9	M6 x 20 BOLT	1.0kgf • m	N27	CAM CHAIN GUIDE ROLLER	
N10	R CYLINDER HEAD SIDE COVER		N28	ROLLER PIN	1.0kgf • m
N12	STOCK CYLINDER HEAD ASSY		N29	8mm SEALING WASHER	
N13	M6 BOLT	1.0kgf • m	N30	DOWEL PIN 8 x 12	
N14	CAM CHAIN				

OPTION PARTS (SUPER OIL PUMP KIT)	
(For application A / B)	331-1013300
(For application C)	331-1083300
OPTION PARTS (CAMSHAFT)	
HIGH CAMSHAFT (For application A)	300-1013000
SPL HIGH CAMSHAFT (For application C)	300-1083100

▲ Sold separately. Please purchase in necessary.  
△ If installing big bore kit, recommend to install oil pump together to match the tuning.  
△ If installing high camshaft, increase the performance. However, limited application. Be careful of it.

**INSTALLING BIG BORE KIT SURROUNDING PARTS**



▲ Basically, reuse genuine parts if it is unattached.

If there is a hard degradation like a blem, fatigue and wear etc on the reuse parts, please change to new ones.

**HOW TO INSTALL**

- 11 Remove piston pin clip on both sides of piston by pliers, etc to remove, push out piston pin to remove piston.
- 12 Install piston ring to piston, then install piston pin and pin clip. Be careful of piston direction when installing. Insert one side of pin clip, insert pin matches to conrod, then insert the other side of clip firmly to install.  
\* Apply oil to piston, piston pin and piston ring.
- 13 Install cylinder gasket, rubber seal and 2pcs dowel pin (short) to specified place, assemble cylinder while squeezing piston ring by hand not to damage cylinder inside and piston, then tighten cylinder temporarily with cylinder left side crossed hole M6 bolt. Pull out the cam chain and install cam chain guide roller with roller pin and sealing washer.  
\* Operate attention 1.
- 14 Install gasket and 2pcs dowel pins (long) to specified place, assemble cylinder head and tighten cylinder head temporarily with cylinder head left side crossed hole M6 bolt.  
\* When installing head gasket, fix the gasket ring and cylinder I.D with a little bit of glue ease to install cylinder head.
- 15 Install head cover gasket (it only matches 1 place, must match it) and cylinder head cover, tighten nut and sealing washer each 4pcs diagonally with specified torque. Tighten cylinder and cylinder head left side crossed hole M6 bolt additionally to install.
- 16 Set the valve timing as illustration. (Refer to No.4)
- 17 Adjust valve clearance. (Refer to No.4)
- 18 Install tappet cap O ring to 2pcs of stock cylinder head tappet cap.
- 19 Install cylinder head sided cover gasket, then install cylinder head side cover with stock M6 bolt 3pcs and sealing washer.  
\* For application B/C, 2 types of right side head side covers are attached. Please use compatible one to match the model and year.
- 20 Install muffler gasket and muffler, then pour specified amount of engine oil. Make sure drain bolt is tightened firmly. \*In case of install oil cooler, etc, add the additional amount for oil cooler capacity.
- 21 Rotate kick pedal slowly to check the crank rotates smoothly, then install plug and plug cap. Put the all removed parts back to finish installation.  
\* Check the carburater drain screw, fuel cock, etc carefully.

